Work Order January-30-14 11:			*112	244:	3*					* *	,	Page 1	=
Revision ID:	3575-2 argo Floor Protector		Accept	*N!	900	040	100)*	-	Start Stop		S1* S2*	=
Start Date: 1/2 Required Date: 1/2 Reference:	30/14 Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			st Item I stomer:	D:							
Approvals: P	Process Plan:	Date: <u>1462-03</u>	Tooling: _ SPC (Y/N):			ate:]		Start Stop		R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	7	ool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject lumber	Insp. Stamp	_
Draw Nbr	Revision Nbr												
D3575	Rev A												
*100 *100* Waterjet FLOW CNC Waterjet		URE SIDE UP*** ber Dwg D3575	0.00		}			2	6			<u>Imiy-o</u> u-	8
į	Dwg Rev	1											
	2-Deburr												
110 *11 0 *	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00					2	٥			Jn140	4 - (

Quality Control

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE			_		AEROSPACE
QA Closed:		-	Date:							· · · · · · · · · · · · · · · · · · ·	Wo	rk Order up	date only		
Work Orde	r:					DISPOSITION	Ì			AGAINST (DEP	PARTMENT	PROCESS		
	•				_	Rework			Skid-tube	Crosstube	***		Water Jet		Engineering
Part N	о.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	О.				_	Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	n	QC Inspector
Design															
Doc/Data	_										ļ				
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Material	_														
Operator	_														
Offset/Setup	괵														
Process	_			:					1						
Supplier															
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Transport															
Unapproved	-				_	MR. C.	<u></u>		TECODY						
							FA	ULI CA	TEGORY						
Landir	ig c	Bending				General Bend		احمانه را	Program	Г		Outside Dim	onsions I		Pressure/Forced
<u> </u>	-	Centre No	nt Concor	atric		BOM/Route	\vdash	Grain	riograffi	-	-	Over/Under			Set-up
		Cracks	ot concer	ILIIC	\vdash	Broken/Damage/Defect	-	Hardwa	aro	<u> </u>	\neg	Part Incorred			Temperature/Cure
}		Crimp/Kir	nk/Rinnle	/\M/ave	-	Burrs	⊢	4	ion Incomplete/Un	nualified	-	Part Lost/Mi			Weld
}		Cuffs	ку прріс	, wave		Contamination	<u> </u>	1	tions Incomplete/U	·		Part Moved	331116		Wrong Stock Pulled
		Crushing			-	Countersink	<u> </u>	4	gned/off center	ricicar	-	Positioned V	Vrong	L	TWO ONE STOCK T direct
 		Heat Trea	ıt		-	Cut Too Short	\vdash	Mislab		}		Power Loss/			Other
		Inspection		Tube		Drawing	<u> </u>	Misrea		L					[···
	_	Marks/Ch	-			Drill Holes	<u> </u>	Off-set			•				
		Turning S				Finish	<u> </u>	-	Calibration		•				
		Wave/Tw	=			Fit/Function		4	Sequence		•				

Work Orde	- ID 1124	1/12		***									
January-30-14 1.				*112	44:	۲×							Page 2
Revision ID:	D3575-2 Cargo Floor Prot	ector	A	Accept	*N	9000	140	100)*	Setup	Start Stop		S1* S2*
Start Date: 1 Required Date: 1 Reference:		Start Qty: 2.00 Req'd Qty: 2.00	*9*			st Item ID stomer:) :						
Approvals:			Date:	Tooling: SPC (Y/N):		<u> </u>	te:			Run	Start Stop	^ \	R1* R2*
Sequence ID/ Work Center ID 120 *1 20* QC Quality Control 150 *150* Packaging Packaging		Decration Description QC8- Inspect parts - seco Memo dentify as per dwg & Sto		Set Up/ Run Hours 0.00 939 0.00	,	ool ID	Tool#	Plan Code	Accep Qty	Qt:		Reject Number DAS 32 9-89	Insp. Stamp
160 *1 AN* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					_ _ M	23_	<u>14</u> 0	9 <u>4 €</u> G √¶	

DQA:			Date:										TO MARY			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE			AEROSPACE			
QA Closed:			Date:							W	ork Order up	date only				
Work Orde	r:					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
	•				_	Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other			
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]	Supplier				
Root	_				Desc	ription of work order update	ᅢ	nitial	Acti	On.	Sign &		-			
Cause	ļ	Date	Step	Qty	Desci	or non-conformance	l	ief Eng	i		Date	Verification	QC Inspector			
Design		Date	Jiep	α.,		or non-comormance	 	iici Eiig	Desci.	ption	Dute	remidulon	Qu'inspector			
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							FA	ULT CA	TEGORY							
Landir					_	General		1 .			7		¬			
		Bending			\vdash	Bend	<u></u>	4	Program	_	Outside Dim	<u> </u>	Pressure/Forced			
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under		Set-up			
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	ļ	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Un	· -	Part Lost/Mi	ssing	Weld			
	-	Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled			
		Crushing			\vdash	Countersink	\vdash	1 '	gned/off center	_	Positioned V		704			
		Heat Trea		T b -	\vdash	Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other			
		Inspectio	-	iupe	-	Drawing Drill Holos	-	Misrea								
		Marks/Ch			-	Drill Holes	\vdash	Off-set				····				
		Turning S Wave/Tw			-	Finish Fit/Function	\vdash	4	Calibration Sequence			, a., . 				
1		vvave/ iW	vist in Tub	Je	L	ן דוני דעווכנוטוו		Jour or	sequence							

Picklist Print Page 1 January-30-14 11:43:43 AM 112443 Work Order ID: D3575-2 **Start Date:** 1/30/14 Required Date: 1/30/14 Parent Item: Start Qty: 2.00 Required Qty: 2.00 Cargo Floor Protector **Parent Item Name:** IPP Rev : A New Issue 07-01-22 EC **Comments:** Component Item ID/ Replacement Last Unit of Qty on Qty per Kit Total Qty Date Status Mfg/ Bin **Primary** Route **Item Name** Item ID Location Seq ID Measure Hand Issued Issued Qty Purch Item Location (19) MLEXS.125-F60029-04 100 sf 2,684.9900 8 No Purchased Jan 4-04-8 GE PLASTICS LEXAN SHEET Loc Code **Location** Loc Qty 2684.99 MAT019 106 124866 479.99 m126425 127934. 2099 m127934

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				_		AEROSPACE
QA Closed:			Date:								Wor	rk Order up	date only		
Work Orde	or.					DISPOSITION				AGAINST [DEP.	ARTMENT/	PROCESS		
WOIK OIGE	•				—	Rework			Skid-tube	Crosstube	\neg		Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab	_	Proc	d. Eng. Coor.	┪	Quality
	•			****		Use-as-is			noforming	Finishing	\exists		e/Packaging	ヿ	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	╛	
														_	
Root					Desci	ription of work order update	i	nitial	Actio			Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	_	Date	Verification	\dashv	QC Inspector
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Doc/Data	Н														
Equip/Tooling															
Handling/Pre	_														
Material		,					Į							-	
Operator Offset/Setup						•									
Process															
Supplier															
Training											-				
Transport											- 1				
Unapproved												-		i	
		•					FA	ULT CA	TEGORY						
Landi	ng (Gear				General		_		_			_		
		Bending				Bend		Folio/I	Program		<u></u>	Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			(Over/Under	tolerance		Set-up
		Cracks			L	Broken/Damage/Defect	L	Hardwa	are	ļ		Part Incorred	:i _	╝	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	tion Incomplete/Und	qualified	'	Part Lost/Mi	ssing	_	Weld
İ		Cuffs	-			Contamination		4	tions Incomplete/U	nclear		Part Moved	L	╝	Wrong Stock Pulled
	_	Crushing			\vdash	Countersink		-	gned/off center]	\rightarrow	Positioned V			
	_	Heat Trea				Cut Too Short		Mislab		L		Power Loss/	Surge		Other
		Inspection	•	Tube	<u> </u>	Drawing	<u>_</u>	Misrea			_				
	_	Marks/Ch				Drill Holes		Off-set			_				
	_	Turning S	-		\perp	Finish		4	Calibration		_	- **.			
1	1	Wave/Tw	ist in Tub	oe -	l	Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	112443
Description: Cabin Floor Protector	Part Number:	D3575-2
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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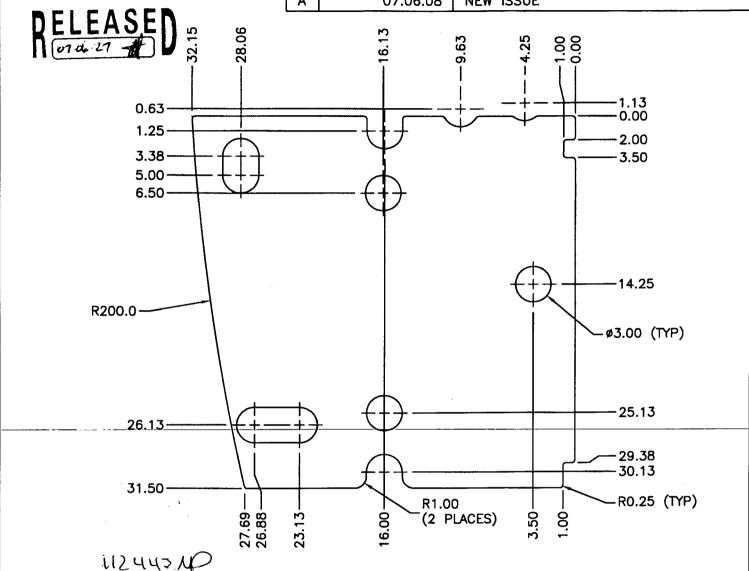
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	_		V	JEM05
1.00	+/-0.030	1.000	_		V	
3.50	+/-0.030	3.50	_		V	
16.00	+/-0.030	16,000			T	Jam 07
23.13	+/-0.030	23.13	_		Τ	
26.88	+/-0.030	26.88"	_		アイ	
27.69	+/-0.030	27.69"	_		. *	
4.25	+/-0.030	4.250			V	
9.63	+/-0.030	9.63	_		V	Jkm08
16.13	+/-0.030	16.13	_		T	
28.06	+/-0.030	28.06"	_		丁	
32.15	+/-0.030	32.15"	_		丁	
2.00	+/-0.030	2.000			v	
3.50	+/-0.030	3.50				
14.25	+/-0.030	14.250	_		7	
25.13	+/-0.030	25.13"	-		٦	
29.38	+/-0.030	29.38"	_		۲	
30.13	+/-0.030	30.134	•		Т	
1.25	1/0.020				V	
1.25	+/-0.030	1.25"			<u> </u>	
3.38	+/-0.030	3.38"			V	
5.00	+/-0.030	5.00	_	-		
6.50	+/-0.030	6.50"			<u>V</u> .	
26.13	+/-0.030	26.13			<u> </u>	
31.50	+/-0.030	31.500	OAS-		7	

Measured by:	Im	Audited by:	9-89	Prototype Approval:	N/A
Date:	14-04-8.	Date:	14/4/8	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.29	New Issue	KJ/DD O	







NOTES:

- MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE

14.02-02

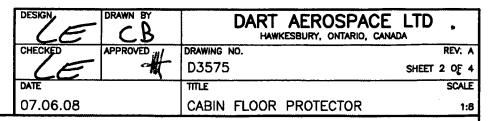
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

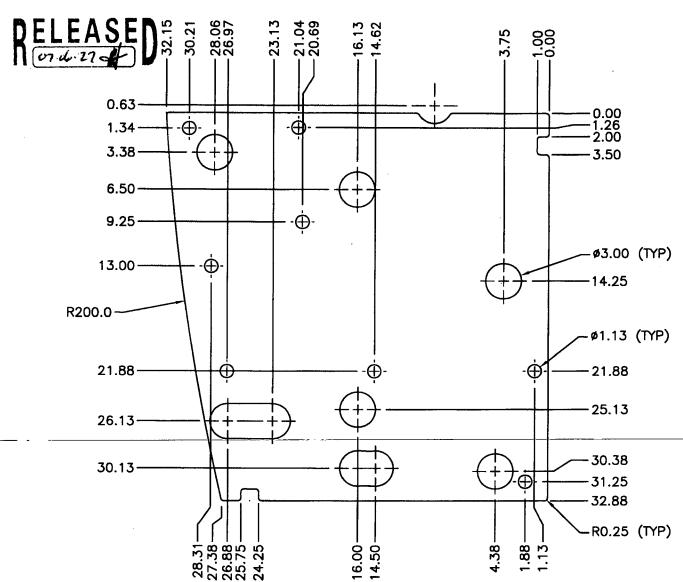
D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

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D3575-3 CABIN FLOOR PROTECTOR

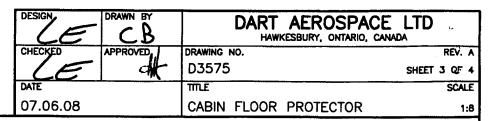
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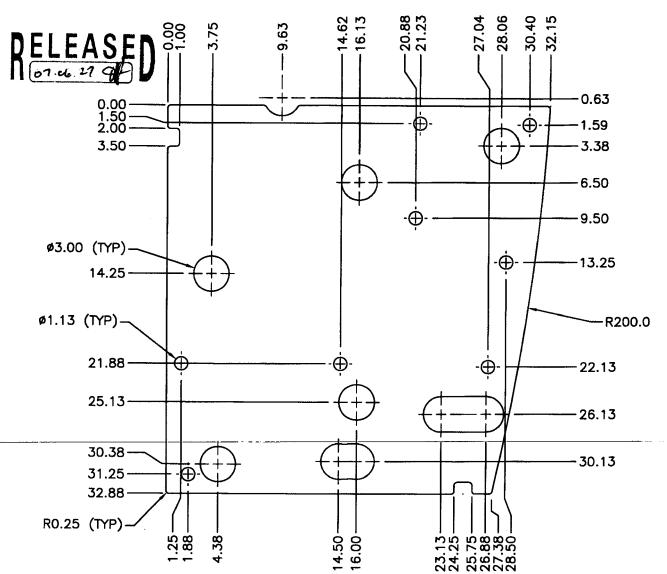
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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D3575-4 CABIN FLOOR PROTECTOR

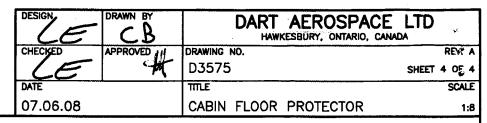
NOTES:

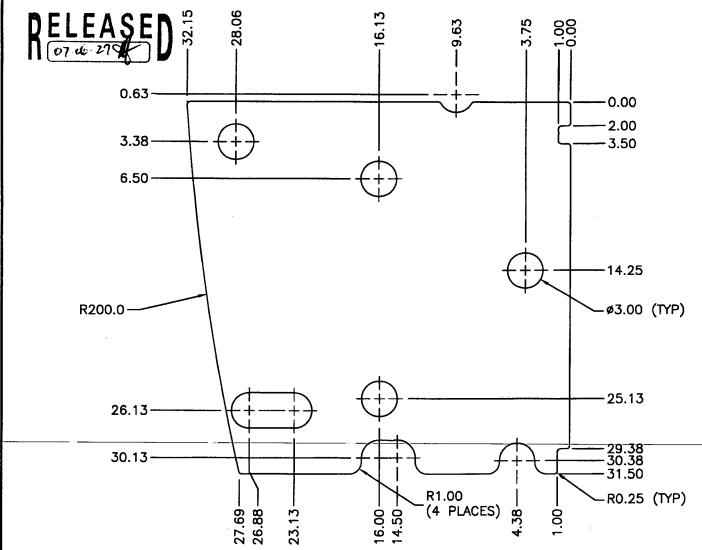
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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